Work Order ID 1 June-24-13 2:11:55 PM	03685		*103	685*				-		Page 1
Item ID: D2938-2 Revision ID:		. /	Accept	*N900	<u>040</u>	100)* s	etup Star	t *N:	S1*
Item Name: 206 Saddle		5						Sto	*N:	S2*
Start Date: 6/24/13	Start Qty: 6.00	*6* -	, «	Cust Item I	D:		•.			
Required Date: 7/05/13	Req'd Qty: 6.00	*6*		Customer:						
Reference:	·		· .		~ 	_		un Star		
Approvals: Process F	Plan: 415	Date: 13-06-25	Tooling: _	D:	ate:		, R		" 	R1*
		·	SPC (Y/N):	D:	ate:			Sto	` *N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr R	evision Nbr									
D2938 R	ev C	·								
100			0.00				P			
100 HAAS 1	HAAS CNC VERTICA	AL MACHINING #1	0.00				_6_			J. 13-8-17
HAAS CNC vertical machine #1	number are inspect as	art number and batch number, e programmed correctly,2-Ma per dwg I)2938 & attached D ad visually inspect as per	1-Inspect part number a	o and visually						
110			0.00 < 4	S				•	•	ı
*11 0 *	CONVENTIONAL MI	LLING MACHINE	~•	3/08/	22		6	Ø		V12-
Mill Conv	Memo		0.00	`				_~	-	
Conventional Milling Machine	Machine K	Keyway and inspect per attach	ed dimension sheet							
120	QC1- Inspect dimension	ons to dimension sheet	0.00	***						
120			AS		•					<u>7773-8-17</u>
QC	Memo		0.00	9 19 4				. u uuu	-	

Quality Control

DQA:		_ Date:												TO A C.
					WORK ORDER NON	-C(ONFO	RMANCE / UF	PDATE					AEROSPACE
QA Closed:		Date:						==		W	ork Order uj	pdate only		
Work Order:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
				_	Rework			Skid-tube	Crosstube	Γ]	Water Jet		Engineering
Part No.					Scrap] :	Machining	Small Fab	_	Pro	d. Eng. Coor.	H	Quality
					Use-as-is	1	Thern	noforming	Finishing	Г	1	re/Packaging		Other
NCR No.	·			—	Suspected Unapproved]		Large Fab	Composite			Supplier		
Root				Desc	ription of work order update		Initial	Acti	ion		Sign &	<u> </u>		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	iption		Date	Verificatio	n	QC Inspector
Design	1													
Doc/Data	4							ľ						
Equip/Tooling	4													
Handling/Pre														
Material	4					1						·		
Operator	4					1								
Offset/Setup	1										4			
Process	-										•	,		
Supplier	· ·													
Training Transport	1													
Unapproved	1] ;												
Опарриосса		1			**	FΔI	HT CAT	L TEGORY			<u>. </u>			
Landing	Gear			<u> </u>	General		v.	- LOOK!						
٦	Bending				Bend	冖	Folio/P	rogram			Outside Dim	ensions		Pressure/Forced
	Centre No	ot Concer	ntric		BOM/Route		Grain	J			Over/Under		\vdash	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorrec	••		Temperature/Cure
	Crimp/Kir	nk/Ripple,	/Wave		Burrs		Inspecti	on Incomplete/Uni	qualified		Part Lost/Mi	ssing	\vdash	Weld
	Cuffs				Contamination	-,	1	ions Incomplete/U	-		Part Moved	_	П	Wrong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center			Positioned V			
	Heat Trea	ıt			Cut Too Short		Mislabe	led			Power Loss/	Surge		Other
	Inspection	n Strip in	Tube		Drawing		Misread	j	'					
	Marks/Ch	atter			Drill Holes		Off-set							
	Turning S	equence			Finish		Out of C	Calibration						
	Wave/Tw	ist in Tub	P		Fit/Function		Out of s	Conuence						

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Ord June-24-13 2:		3685		*10	368	15*							Page 2
Item ID: Revision ID: Item Name:	D2938-2 206 Saddle			Accept	*N	19000	40	100)*	Setup	Start Stop	*N:	S1* S2*
Start Date: Required Date Reference:	6/24/13 e: 7/05/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*			Cust Item ID: Customer:							· .
Approvals:	Process Pla	an:	Date:	_		Date:				Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center 130 *1 30* QC Quality Control	ID	Operation Description QC8-Inspect parts - seco	ond check	Set Up/ Run Hours 0.00	D-0	Tool ID 3	Tool# 22	Plan Code	Accep Qty	t Re Qi 		Reject Number	Insp. Stamp AS O8
140 *14 handFinish Hand Finishing		Chemical Conversion Co	oat per QS1005 4.1	0.00					6		1 <u>G</u> 18	3-870	6
*150 *150* Powdercoat Powder Coating	25	White Gloss(Ref.4.3.5.1) Memo START TIM	IE: LO "	0.00 YO 0.00 _OVEN TEMPERATU					6х.	<i>Ø.</i>	<u>m</u> ,	<u>L13</u> 1	108/2

DQA:		Date:		-,	•			_						TOART
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / UF		Wd	ork Order up	odate only	_	AEROSPACE
			,	_	DISPOSITION					-	PARTMENT			
Work Orde	er:					1		<u></u>	-		1		_	_
					Rework	j		Skid-tube	Crosstube			Water Jet	-	Engineering
Part N	lo				Scrap			Machining	Small Fab	_	1	d. Eng. Coor.	-	Quality
N/CD A	1 _				Use-as-is		Thern	noforming	Finishing		Rec/Sto	re/Packaging	_	Other
NCR N	10				Suspected Unapproved	j		Large Fab	Composite			Supplie	L] []
Root				Desc	ription of work order update		Initial	Acti	ion		Sign &			-
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	iption		Date	Verification	n	QC Inspector
Design														
Doc/Data		İ												
Equip/Tooling						İ								
Handling/Pre														
Material さく						ŀ								
Operator	_	1												
Offset/Setup		İ												
Process														
Supplier	_	ļ									-			
raining														
Fransport	_	1												
Jnapproved		i	<u> </u>	l			 .							
						FA	ULT CAT	TEGORY						
Landin	g Gear			_	General	_	1		۲		1		_	7
	Bending			\vdash	Bend	<u> </u>	4	rogram	-	_	Outside Dim		<u></u>	Pressure/Forced
-	Centre No	ot Concer	ntric	-	BOM/Route	<u> </u>	Grain		-	\rightarrow	Over/Under		\vdash	Set-up
-	Cracks		4	\vdash	Broken/Damage/Defect	_	Hardwa			-	Part Incorrec		\vdash	Temperature/Cure
}	Crimp/Kit	nk/Ripple	/Wave	-	Burrs	<u> </u>	1 `	on Incomplete/Un	· -		Part Lost/Mi	ssing		Weld
}_	Cuffs			\vdash	Contamination	<u> </u>	4	ions Incomplete/U	nclear	_	Part Moved			Wrong Stock Pulled
-	Crushing			<u> </u>	Countersink		1	ned/off center	Ļ	-	Positioned V	-	_	٦
	Heat Trea		- 1	<u> </u>	Cut Too Short	<u> </u>	Mislabe		L	\perp	Power Loss/	Surge		Other
-	Inspectio	•	Tube	<u> </u>	Drawing	<u> </u>	Misread	1						
	Marks/Ch			-	Drill Holes	<u> </u>	Off-set							
	Turning S				Finish		4	Calibration						
	Wave/Tw	rist in Tub	e e		Fit/Function	l	Out of S	Sequence						

Work Ord June-24-13 2:1		3685		*10:	3685	5 *							Page 3
Item ID: Revision ID: Item Name: Start Date:	D2938-2 206 Saddle 6/24/13	Start Qty: 6.00	*6*	ccept	Cus	st Item I	040 D:	100)*	Setup	Start Stop	ı Vı	S1* S2*
Required Date Reference:	; //03/13	Req'd Qty: 6.00	*6*		Cu	stomer:							
Approvals:		an:	·	Tooling: SPC (Y/N):			ate:	-	1	Run	Start Stop	[7]	R1* R2*
Sequence ID/ Work Center I 160 *160* QC QC Quality Control	ID	Operation Description QC3- Inspect Part Finish Memo		0.00 2 9-	AS 27 89 & 27	ool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
170 *170* Packaging Packaging		Identify as per dwg & Sto Memo	ck Location: <u>ST438</u>	0.00					6x	<u>/</u> —	_ N	1 <u>.10.</u>	<u> 13-08</u> -
180 *180* QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00						<u> /</u>	3/	8/2	7 X
										Ą	J (i	Joseph Control	

DQA:		<u> </u>	Date:										TOADT
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDA	NTE			AEROSPACE
QA Closed:			Date:							W	ork Order up	odate only	
Work Orde	er:			•		DISPOSITION			Д	AGAINST DE	PARTMENT	/PROCESS	•
	-					Rework			Skid-tube Cr	rosstube]	Water Jet	Engineering
Part N	No.					Scrap			├	mall Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is		Therr	noforming F	Finishing	Rec/Stor	re/Packaging	Other
NCR I	No.					Suspected Unapproved			Large Fab Co	mposite		Supplier	
Root					Desci	ription of work order update		Initial	Action	_	Sign &		·
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descriptio	n	Date	Verification	QC Inspector
Design													
Doc/Data						,							
Equip/Tooling													
Handling/Pre	Щ										:		
Material	Ш												
Operator	Ш		1		<u> </u>								· ·
Offset/Setup	Щ		}										
Process] .									
Supplier	Щ												
Training	Ш										!		
Transport	Н												·
Unapproved			<u> </u>	<u> </u>			<u> </u>						
				 .	<u> </u>		FAI	ULT CA	EGORY				
Landii						General]			1		7
	\vdash	Bending			_	Bend BOAA/Danaba		•	rogram	<u> </u>	Outside Dim	⊢	Pressure/Forced
	_	Centre No	ot Concer	TEFIC	-	BOM/Route		Grain		<u> </u>	Over/Under	├ -	Set-up
	-	Cracks	d./Dimmlo	AMous	-	Broken/Damage/Defect		Hardwa			Part Incorred		Temperature/Cure
	-	Crimp/Kin	ik/kipbie	/ wave		Burrs	_	1	ion Incomplete/Unquali	· · · · · · · · · · · · · · · · · · ·	Part Lost/Mi		Weld
	\vdash	Cuffs Crushing				Contamination Countersink		•	ions Incomplete/Unclea	dī I	Part Moved		Wrong Stock Pulled
		Crustling Heat Trea	ıt			Cut Too Short	_	Mislabe	ned/off center	<u> </u>	Positioned W		Tother !
	-	Inspection		Tube	-	Drawing		Misread		L	Power Loss/:	onige [Other
	-	Marks/Ch	•	TUDE		Drill Holes		Off-set	1			. <u>. </u>	
	\vdash	Turning So			<u> </u>	Finish		4	Calibration		_		
	_	Wave/Tw				Fit/Function		1	Sequence				
	<u> </u>				1								

Picklist Print

June-24-13 2:11:54 PM

Work Order ID:

103685

Parent Item:

D2938-2

Parent Item Name:

206 Saddle

Start Date: 6/24/13

Required Date: 7/05/13

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP: B 00.06.26 New DWG rev (mpp 2069)EC IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 Saddle Billet, 7075		Manufactured	No			100	Each	48.0000	16	6 	ld 13-	08-11	e
				Location		Loc Oty	<u>Lo</u>	c Code					
				MAT042		2			· .				
				9841	.7	2							
				MAT045		46				<u></u>			
				9756	53	46							
				102	142					9			

DQA:		_ Date:										TOACT
,					WORK ORDER NON	-C(ONFO	RMANCE / UPI			–	AEROSPACE
QA Closed:		Date:			· · · · -					Vork Order u	pdate only	
Work Orde	er:	*			DISPOSITION			.	AGAINST D	EPARTMENT	/PROCESS	
	· · · · · · · · · · · · · · · · · · ·			_	Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	۱o.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is			noforming	Finishing	 :	re/Packaging	Other
NCR N	No.				Suspected Unapproved			Large Fab	Composite	7	Supplier	7
					<u></u>	•			_	<u> </u>		
Root				Desci	ription of work order update		Initial	Actio	n	Sign &		
Cause	Date	Step	Qty		or non-conformance	Cr	nief Eng	Descrip	otion	Date	Verification	QC Inspector
Design			1									
Doc/Data												
Equip/Tooling					İ						ļ	ĺ
Handling/Pre												
Material												
Operator												
Offset/Setup			l i		i						-	
Process	!											
Supplier												
Training	_											
Transport												
Jnapproved		.]										
·						FA	ULT CAT	regory				
Landir 1	ng Gear			r	General		1 .		_	_	_	_
	Bending	_			Bend		1	'rogram	-	Outside Dim	├	Pressure/Forced
-		ot Concer	ntric		BOM/Route	┡	Grain		<u> </u>	Over/Under	—	Set-up
	Cracks				Broken/Damage/Defect	L	Hardwa		_	Part Incorre	}—	Temperature/Cure
		nk/Ripple	:/Wave		Burrs	┡	1	ion Incomplete/Unq	<u> </u>	Part Lost/Mi	issing	Weld
}	Cuffs			<u> </u>	Contamination	<u> </u>	4	ions Incomplete/Un	clear	Part Moved		Wrong Stock Pulled
	Crushing				Countersink	<u> </u>		ned/off center	<u> </u>	Positioned V	_	7
	Heat Trea				Cut Too Short	<u> </u>	Mislabe		Ĺ	Power Loss/	Surge	Other
		on Strip in	lube		Drawing	<u> </u>	Misread	i				
}	Marks/Cl				Drill Holes	\vdash	Off-set					
		Sequence vist in Tub		\vdash	Finish Fit/Function	_	4	Calibration -				
,	IWave/Tw	vist in Trib	16	- 1	LEIT/EUNCTION		IOut of 9	Seguence				

DART AEROSPACE LTD	Work Order:	103685
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Re	corded Act	ual Dimensi	ions		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.100	0.140		124	. 121	-120	-120		<u> </u>
В	0.100	0.140		1-124	121	120	-120	i	
С	0.100	0.140		-120	- 114	-117	-115		
D	0.210	0.230		225	-220	-220	1-220		
Ε	1.245	1.255		1,250	1.250	1,250	1,250		
F	1.245	1.255		1 250	1-250	1,250	1-250		
G	2.495	2.505		2.500	2.500	2.500	2-500		
Н	0.510	0.515		.512	-512	-5/2	·5/2		
!	1.572	1.582		1,577	1.577	I STI	1.577		
J	2.495	2.505		2.500	2.500	2-500	2,500	 	
K	0.257	0.262		-258	-258	322	1258		
L	0.312	0.317		214	314	314	-314	 	
M	0.235	0.240	•	238	.238	- 238	. 238		
N	9.100	0.140		-122	-121	-120	120		
0	0.540	0.560		549	- 550	-549	549	 	
Р	0.490	0.510		- 500	- 503	- 499	-500		
Q	3.715	3.725		3,720	3.7.00	2,720	3-7-20	 	
R	2.720	2.760		2.740	2740	2.41	2740		
S	0.240	0.270		-260	1250	-253	253		
Т	0.100	0.180		-135	-135	-135	- 135°		
U	1.625	1.635		1-630	1.630	1.630	1.630		
V	1.362	1.372		1-364	1.367	1364	1-367		
W	0.316	0.321		-316	-36	-316	316	 	
Х	1.250	1.270		1256	1259	1,259	1,260	· ·	
Υ	1.565	1.585	_	1570	7.573	1574	1575		
Z	0,178	0.198	**	-188	188	185	-188		
AA		Ì		- 12121					
AB							_	 	
AC								_	
AD				-					
ĀĒ						-			
AF									*****
AG									
AH	.						 		
	Acc	ept/Rejec	t -	!			 		
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				^ ^ ^
Measured by: [5]	44	Audited by I	₩	1747
IVICASAICA Dy.		Addited by j	₩.₽	V
Date: /2-√ - F	1 3-6-	Date	1210010	· - 10 A
Date. 13-8-1	Τ	j Date: [1410014	/ 00
· · · · · · · · · · · · · · · · · · ·				- 9-83

	Date	<u>Change</u>	Revised by	Approved
Α		New Issue	RF	
_B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	1
C	07.03.21	Revised per drawing revision C	KJ/JLM	911

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DART AEROSPACE LTD	Work Order:	103685
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

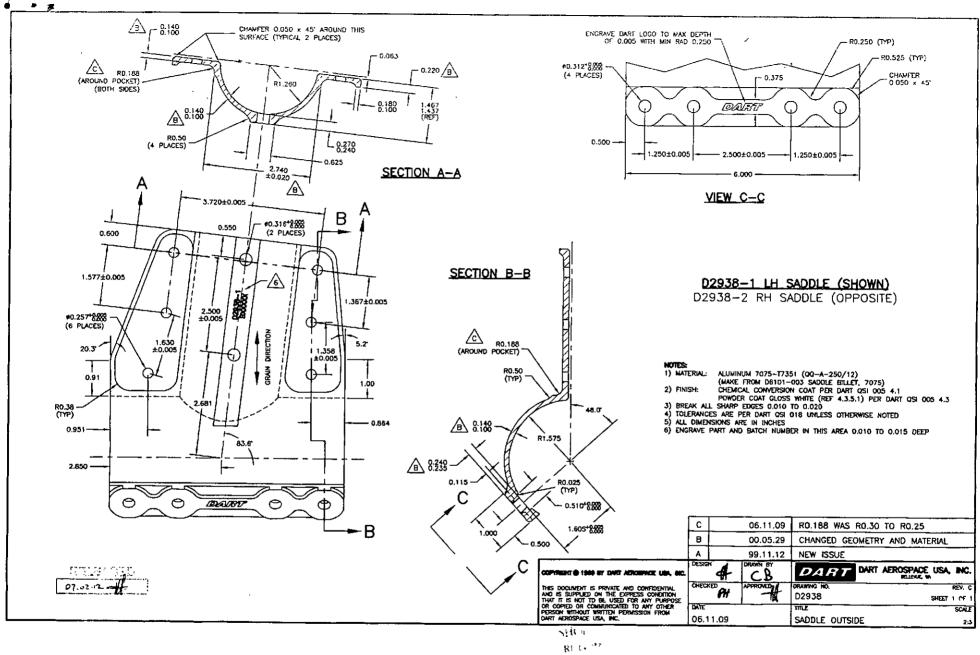
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1/5	3/C	3	4	Ву	Date
Α	0.100	0.140		-121	. 121			1	
В	0.100	0.140		-121	-121		<u> </u>		
C	0.100	0.140		-116	. jĭ<				
D	0.210	0.230		1220	-220 1.250 1.250		· · · · · · · · · · · · · · · · · · ·		
E	1.245	1.255		1-250	1250				
F	1.245	1.255	,	11-250	1,250				
G	2.495	2.505		2.500	2,500	1			-
Н	0.510	0.515	. -	.5/2	-5/2				
ı	1.572	1.582		. 5/2	1,547				
J	2.495	2.505		2.500	2.500			-	
K	0.257	0.262		258	2258			 	
L	0.312	0.317		2314	-314			· · · ·	
М	0.235	0.240		233	eES.			 	
N	0.100	0.140	•	120	-190				
0	0.540	0.560		- 548	-120 -549			 	
Р	0.490	0.510	- -	- 548 -499	500			1 1	
Q	3.715	3.725		3 t20	·500 3 ·720				
R	2.720	2.760		2,740	2.740	<u> </u>		- -	
S	0.240	0.270		252	-252				
T	0.100	0.180		- 135	-135			1	
U	1.625	1.635		1.30				 	· <u>-</u>
V	1.362	1.372		1-36-1	1.630 1.367			 	
W	0.316	0.321		-316	36			 	
X	1.250	1.270		1060	1,260			 	
Υ	1.565	1.585		1.260	1,575			+	
<u>Z</u> _	0.178	0.198		-188	_188		 	+	<u>_</u>
ĀĀ	-			-14/1)	<u> </u>	<u> </u>	******	 -	
AB		-			·*·	-		 	
AC		The state of the s	 .			 		 	
AD								 -	
AE			-	·		+		++	
AF	-		·	_		· · · · · · · · · · · · · · · · · · ·		 	
.AG	-		· · · · · ·					+-+	_
AH								 	
,	Acc	ept/Rejec	-t			 -		 	<u>-</u>
		יטנטיים ק-)''\S'					

					• =
Measured by:	_SL	2.65	Audited by	M.A	OAG .
Date:	13-8-17	09	Date:	13/08/22	08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	1
С	07.03.21	Revised per drawing revision C	KJ/JLM a	adl
				

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ENGINE
UNCONTROLE
SUBJECTION OF THE WORK OF THE MALE
NO. 103685 MLJ
1306-25

